

Work Order ID 62963



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Thursday, October 14, 2010 12:40:03 PM

| | | | | | | |
|----------------|----------------------------|------------|------|-------|---------------|--|
| Item ID: | D412-742-041 | Accept | | Setup | Start | |
| Revision ID: | | | | | Stop | |
| Item Name: | Replacement Float Skidtube | | | | | |
| Start Date: | 10/14/2010 | Start Qty: | 1.00 | | Cust Item ID: | |
| Required Date: | 10/22/2010 | Req'd Qty: | 1.00 | | Customer: | |
| Reference: | | | | | | |

| | | | | | | | | | | | |
|------------|---------------|--|-------|-------|------------|--|-------|--|-----|-------|--|
| Approvals: | Process Plan: | | Date: | 10-14 | Tooling: | | Date: | | Run | Start | |
| | QC: | | Date: | | SPC (Y/N): | | Date: | | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3391 | Rev.H | | | | | | | | |
| 100 | DOCUMENT CONTROL | 0.00 | | | | | | | |
| DC | Memo | 0.00 | | | | | | | |
| Document Control | If D412-742-041 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-742-041 CHG004 | | | | | | | | |

N/A

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 62963

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Item ID: D412-742-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Float Skidtube

Stop



Start Date: 10/14/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R ☐ Sikaflex-241/-291 ☐ M116495
Expiry date: ☐ 12/01

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.

A/R ☐ Sikaflex-241/-291 ☐ M116495
Expiry date: ☐ 12/01

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

A/R ☐ LPS Procyon ☐ M1114596

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/12



Pro ->

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D412-742-041 PAR #: N/A Fault Category: Design NCR: Yes ☒ No ☐ DQA: [Signature] Date: 11/05/13
 Resolution: Rework Disposition: Rework QA: N/C Closed: [Signature] Date: 11/05/13

| NCR: <u>62963</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------|--|--|---|-----------------------|---------------------------|--|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 11.05.12 | 110 | Aft saddle holes won't allow bolt to install. R.L. Process. | <u>CP</u> 11.05.12 <u>PS/042</u> | Acceptable to file holes to allow assembly | <u>AS</u> 11/05/12 | <u>S</u> 11/07/12 | <u>CP</u> 11.05.12 <u>PS/042</u> | <u>S</u> 11/05/12 |
| | | | | | | | | |
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NOTE: Date & initial all entries

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Item ID: D412-742-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube

Start Date: 10/14/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-742-041 ☐ Location: _____ ☐ PPP Rev: _____

PPP 68633

11/5/12

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/5/12

MF
11-0572

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 62963

Parent Item: D412-742-041

Parent Item Name: Replacement Float Skidtube



Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM
 IPP Rev B 06.02.13 ECN 773 dwg @ rev.D EC
 IPP Rev:C 07-05-28 As per Rev F JLM
 IPP rev D 07.11.01 ecn 1053p EC
 IPP rev E 07.11.27 ecn 1072 EC verified by:DD
 IPP Rev:F 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:G
 10.02.24 as per ECN10-514 DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|--------|--|-----------|----|--|--|-----|------|-----------|----|----|--|--|--|
| AN3C4A | | Purchased | No | | | 110 | Each | 1,361.000 | 24 | 24 | | | |
| | | | | | | | | | | | | | |
| BOLT | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST303 | 3 | M 117313 |
| 115438 | 3 | |
| ST350 | 1358 | |
| 114108 | 14 | |
| 114416 | 12 | |
| 114523 | 2 | |
| 115300 | 330 | |
| 115589 | 1000 | |

| | | | | | | | | | | | | | |
|--------|--|-----------|----|--|--|-----|------|----------|----|----|--|--|--|
| AN3C6A | | Purchased | No | | | 110 | Each | 261.0000 | 12 | 12 | | | |
| | | | | | | | | | | | | | |
| BOLT | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST351 | 261 | M 116419 |
| 111982 | 261 | |

| W/O: | | WORK ORDER CHANGES | | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 62963

Parent Item: D412-742-041

Parent Item Name: Replacement Float Skidtube

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C7A Purchased No 110 Each 110.0000 8 8
BOLT

Location

Loc Qty

Loc Code

ST351

110

M116169

x8

113149

81

114382

29

AN960C10L NAS1149C0332 R Purchased No

110

Each

29.0000

44

44



washer

Location

Loc Qty

Loc Code

ST245

29

M117291

x44

107534

29

AN960C416L Purchased No

110

Each

180.0000

4

4



WASHER NAS1149C0432R (M116900)

Location

Loc Qty

Loc Code

FG

44

104925

44

ST346

136

106785

10

107008

10

112828

75

69220

41

D3391-011 Manufactured No

110

Each

0.0000

1

1



Fwd Tube Assembly

D3391-013

Manufactured No

110

Each

0.0000

1

1



Mid Tube Assembly

B62970(x1) M116900

B62973(x1) M116900

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| W/O: | | WORK ORDER CHANGES | | | | | | |
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Picklist Print

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Work Order ID: 62963

Parent Item: D412-742-041

Parent Item Name: Replacement Float Skidtube

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3391-015



Aft Tube Assembly

D3564-1



Wearshoe

Manufactured No
A
mf used on D3391-013 #62973

Manufactured

No

110

Each

0.0000

1

1



BG2975 (v1) all uloslu

Manufactured

No

110

Each

14.0000

1

1



all uloslu

Location

Loc Qty

Loc Code

FG

2

33798

2

BG4747

xl

FP19

12

58823

12

D3564-3



Wearshoe

Manufactured

No

110

Each

8.0000

1

1



all uloslu

Location

Loc Qty

Loc Code

FG

2

33764

2

FP19

6

55489

1

58825

5

BG4748

xl

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Work Order ID: 62963

Parent Item: D412-742-041

Parent Item Name: Replacement Float Skidtube

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

110

Each

19.0000

1

1



Wearshoe



21105/11

Location

Loc Qty

Loc Code

FG

1

B67588

21

34806

1

FP19

5

57525

1

58709

1

61699

3

FP-19

13

62237

13

D3566-1

Manufactured No

110

Each

3.0000

2

2



Gasket



21105/11

Location

Loc Qty

Loc Code

FP015

3

B68924

22

57715

2

61992

1

D3566-5

Manufactured No

110

Each

17.0000

1

1



Gasket



21105/11

Location

Loc Qty

Loc Code

FP

5

60869

5

FP015

12

B67589

21

62463

12

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| W/O: | | WORK ORDER CHANGES | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Thursday, October 14, 2010 12:40:07 PM

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Work Order ID: 62963

Parent Item: D412-742-041

Parent Item Name: Replacement Float Skidtube

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3591-1

Manufactured

No



Bushing

N
A MF
11-05-12

110

Each

35.0000

2

2



Location

Loc Qty

Loc Code

ST072

35

47121

2

57350

33

D3672-3

Manufactured

No



Phenolic Washer

110

Each

527.0000

4

4



Location

Loc Qty

Loc Code

ST077

527

47023

16

57704

511

MG4176

xd

MS27039C4-12

Purchased

No



SCREW

110

Each

34.0000

4

4



Location

Loc Qty

Loc Code

ST293

34

114221

34

yd

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Shop Packet Print

Page 5

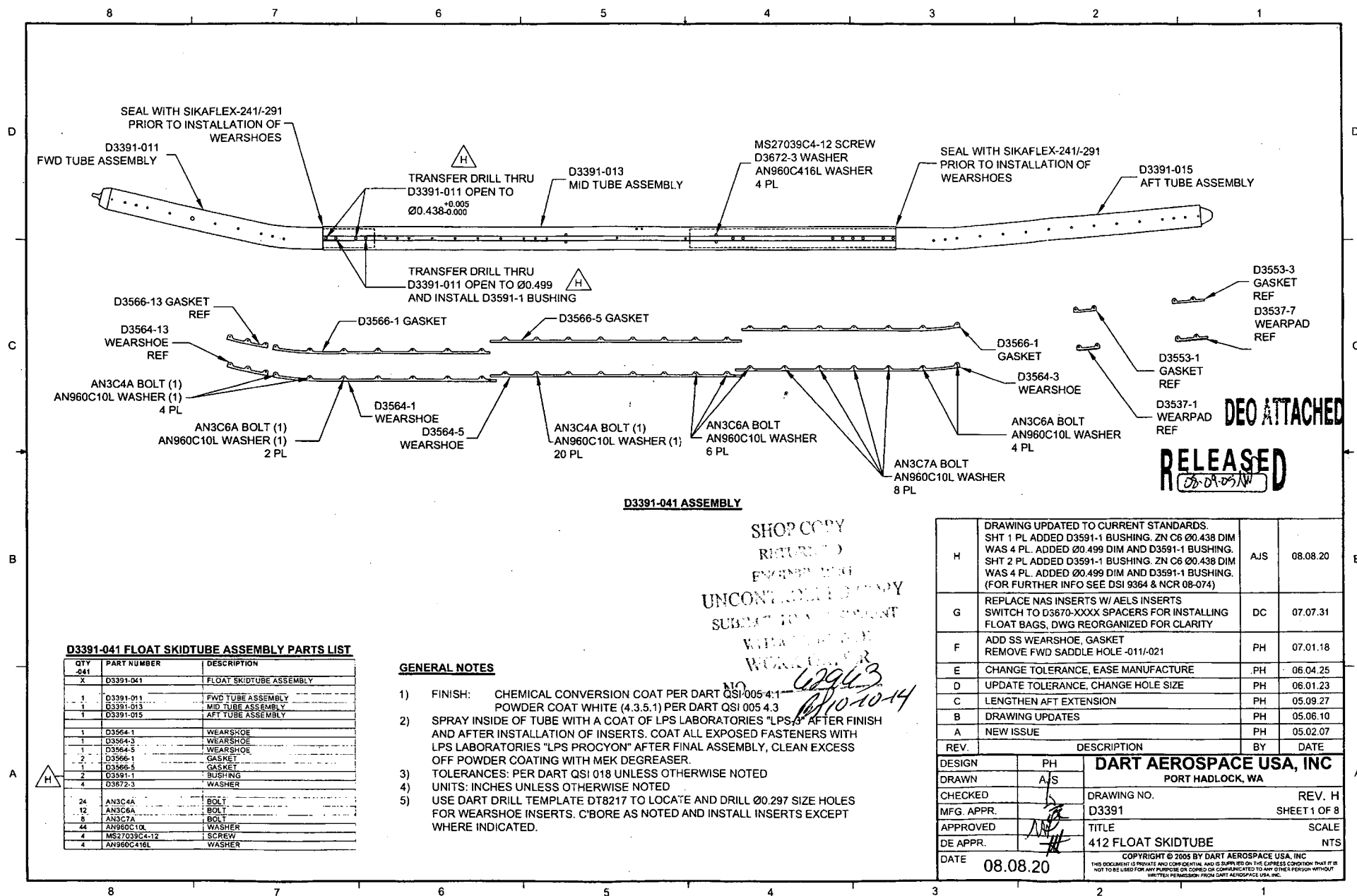
| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



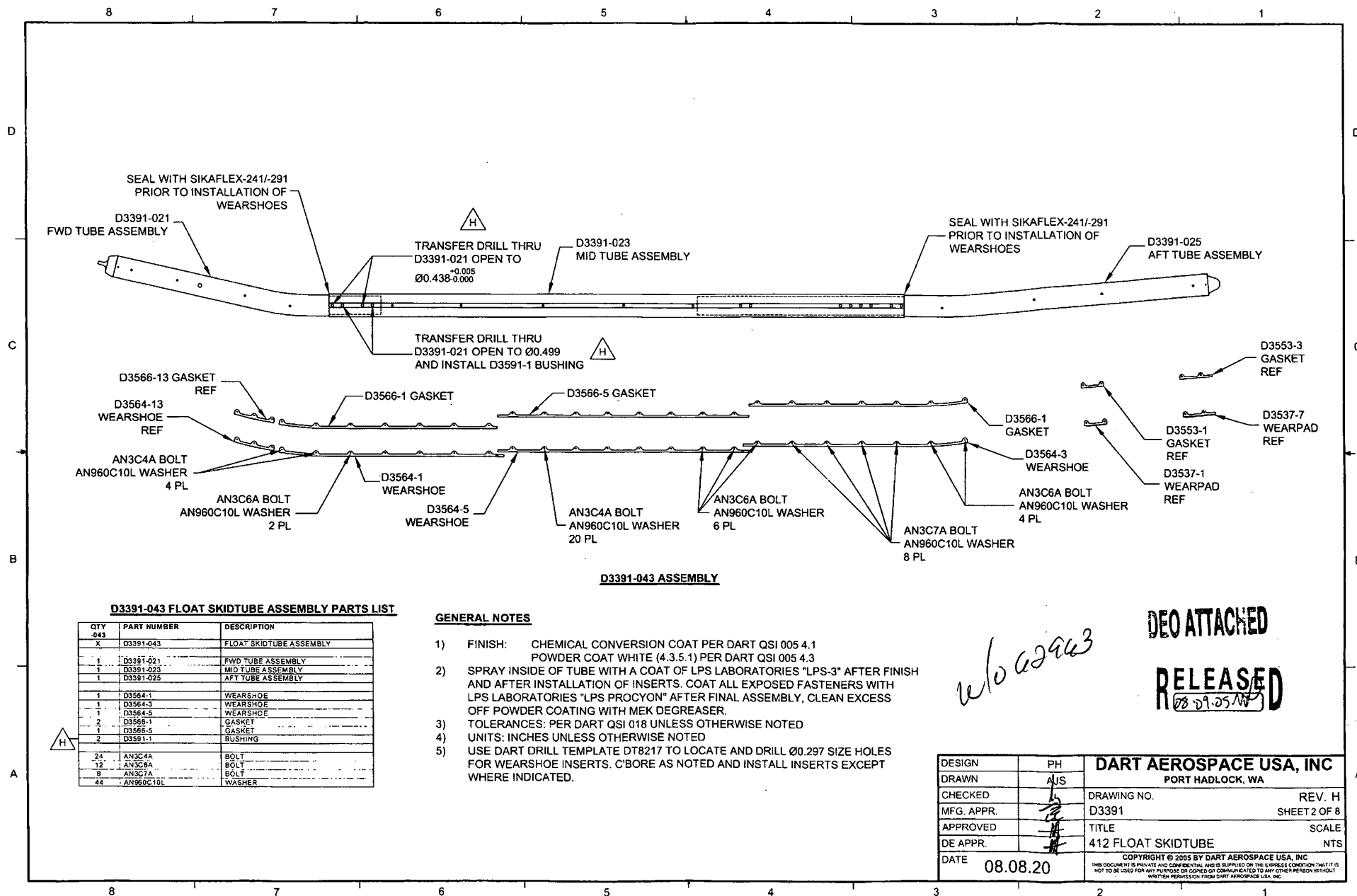
| W/O: | | WORK ORDER CHANGES | | | | | | |
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NOTE: Date & initial all entries



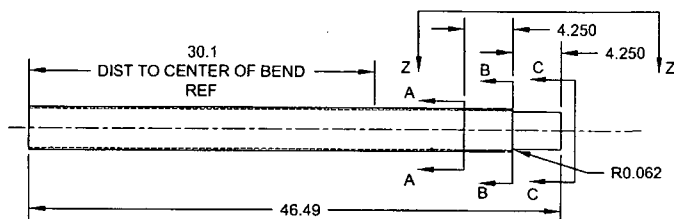
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

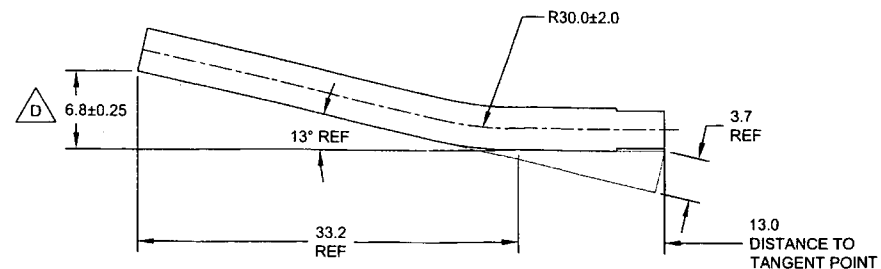
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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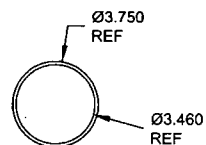
NOTE: Date & initial all entries



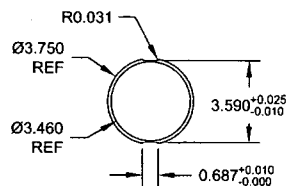
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



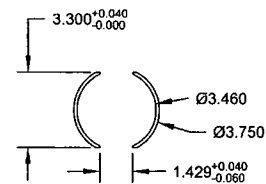
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



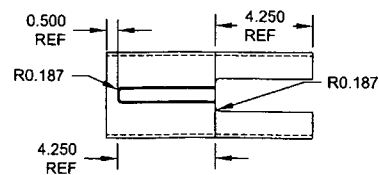
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

u602923

DEO ATTACHED
RELEASED
28 JAN 05

| | | | |
|------------|--------------------|--|--------------|
| DESIGN | PH | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. H |
| MFG. APPR. | <i>[Signature]</i> | D3391 | SHEET 3 OF 8 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | 412 FLOAT SKIDTUBE | NTS |
| DATE | 08.08.20 | <small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

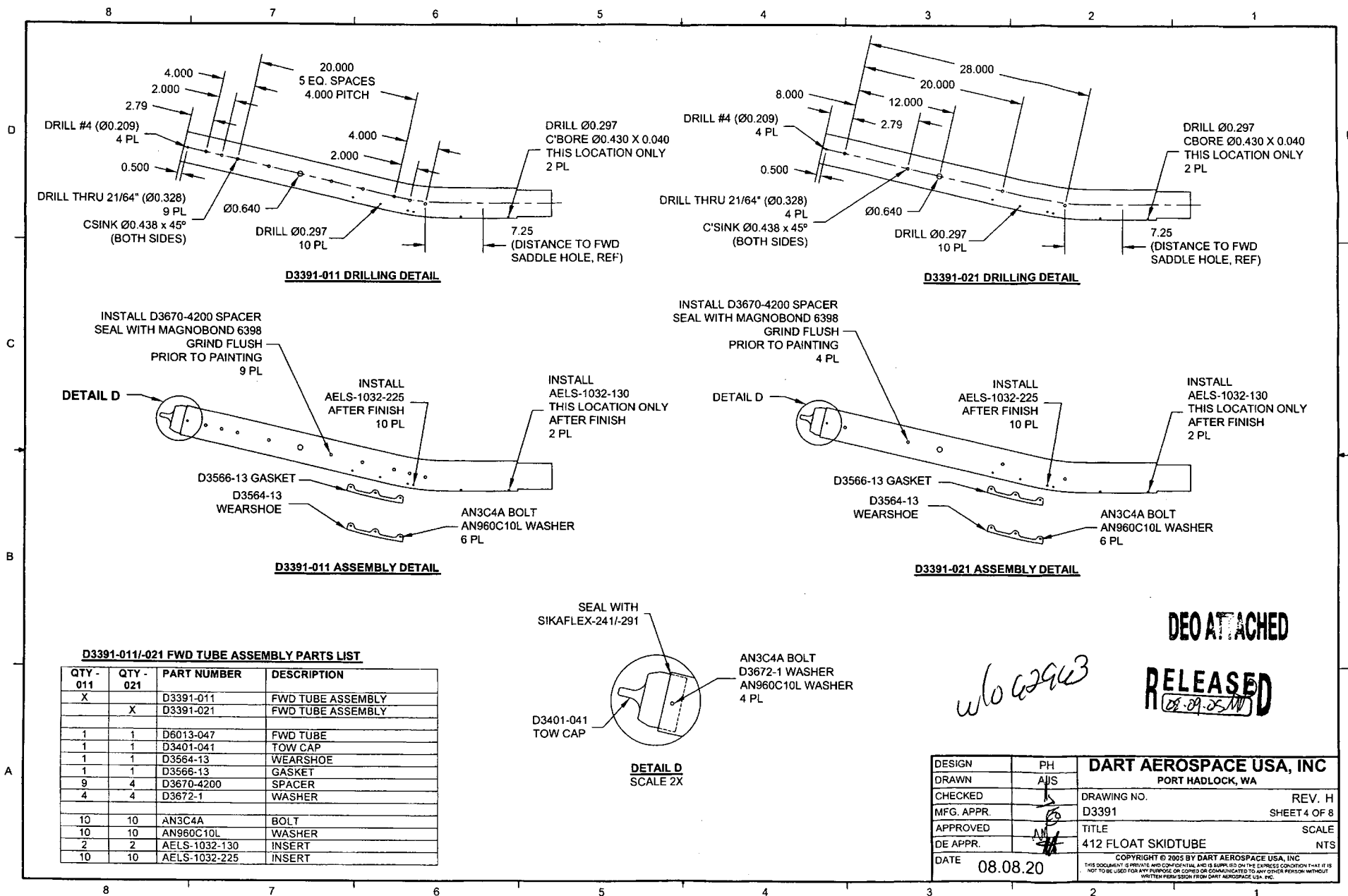
| W/O: | | WORK ORDER CHANGES | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



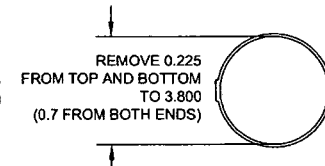
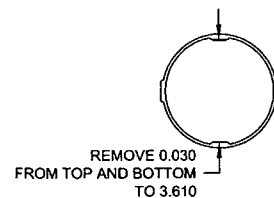
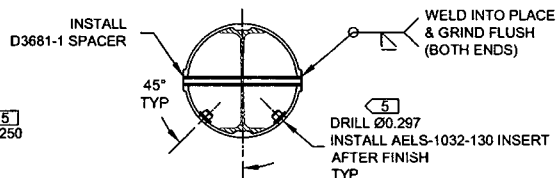
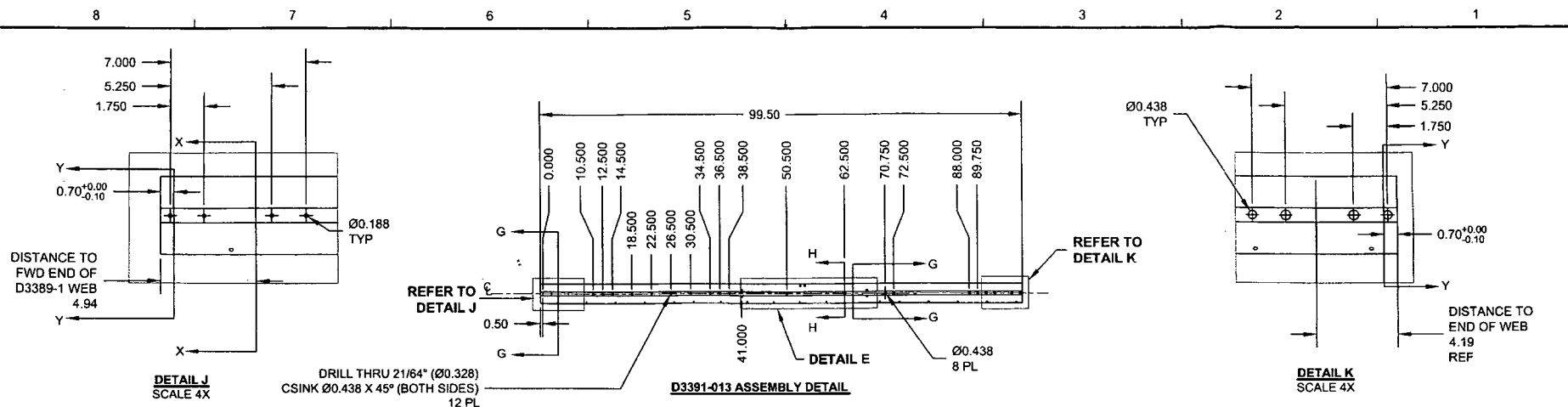
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|------|------|---------------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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NOTE: Date & initial all entries

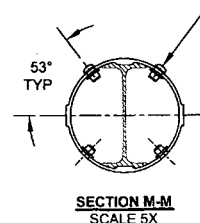
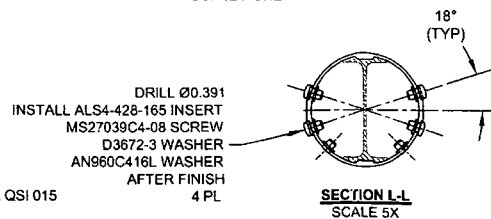
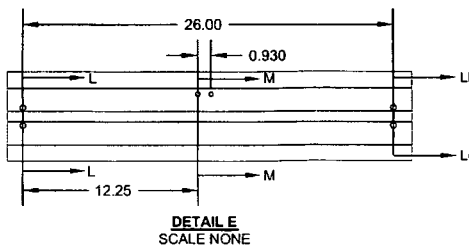


D3391-013 MID TUBE ASSEMBLY PARTS LIST

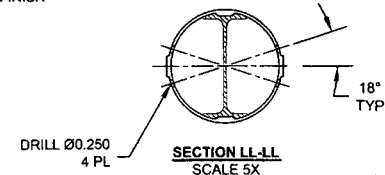
| QTY | PART NUMBER | DESCRIPTION |
|------|---------------|-------------------|
| -013 | | |
| X | D3391-013 | MID TUBE ASSEMBLY |
| 1 | D2500-1-100 | EXTRUSION |
| 1 | D3389-1 | WEB |
| 4 | D3672-1 | WASHER |
| 4 | D3672-3 | WASHER |
| 12 | D3681-1 | SPACER |
| 24 | AELS-1032-130 | INSERT |
| 4 | ALS4-428-165 | INSERT |
| 4 | AN960C10L | WASHER |
| 4 | AN960C416L | WASHER |
| 4 | MS27039C1-09 | SCREW |
| 4 | MS27039C4-08 | SCREW |

D3391-013 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- WELDING: PER DART QSI 004



DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
4 PL



DEO ATTACHED

RELEASED

| | | | |
|------------|----------|---|--------------|
| DESIGN | PH | DART AEROSPACE USA, INC | |
| DRAWN | AIS | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. H |
| MFG. APPR. | | D3391 | SHEET 5 OF 8 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 412 FLOAT SKIDTUBE | NTS |
| DATE | 08.08.20 | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC | |

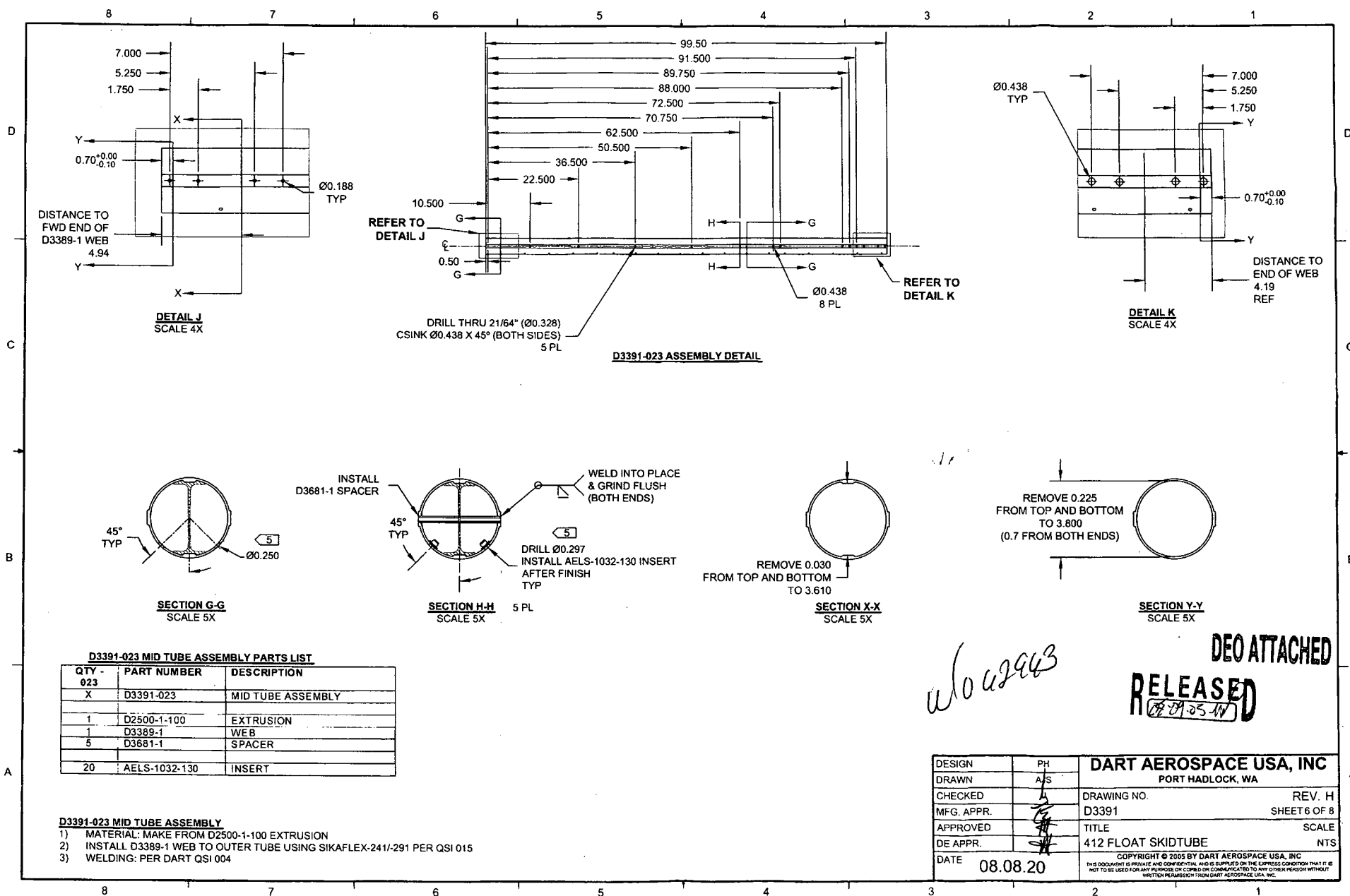
| W/O: | | WORK ORDER CHANGES | | | | | | |
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NOTE: Date & initial all entries



W042943

DEO ATTACHED
 RELEASED
 08-01-05-17

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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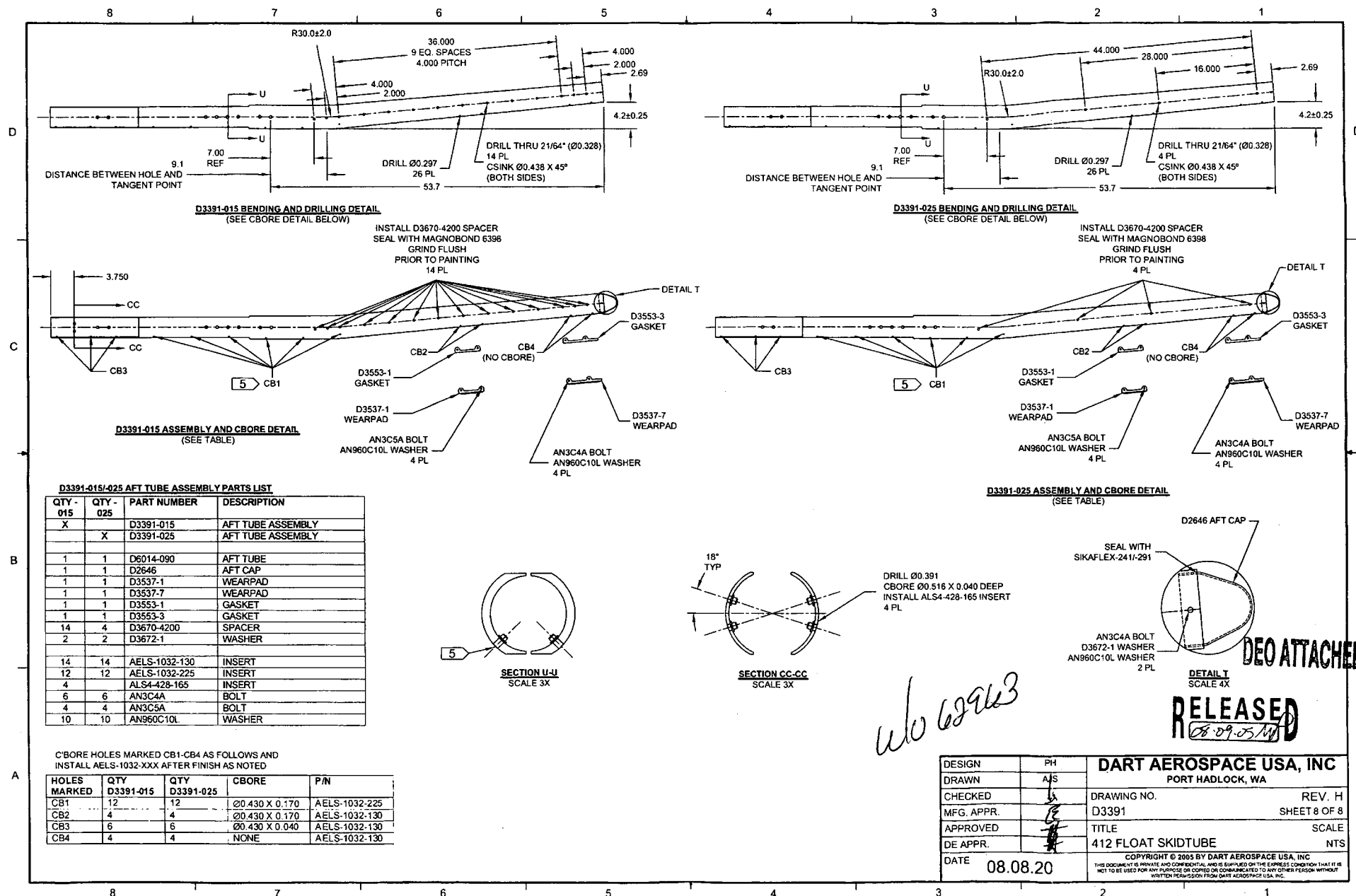
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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

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|----------------------|-----------------------------|-------------------------|--|--|-------------------------|---------------------------|--------------|
| DRAWING NO. D3391 | TITLE 412 FLOAT SKIDTUBE | REV. H | DART AEROSPACE USA, INC ENGINEERING ORDER | | D.E.O. NO. D3391-H-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN <i>JP</i> | CHECKED <i>h</i> | MFG. APPR. <i>MA</i> | APPROVED <i>MP</i> | | DE APPR. <i>h</i> | | |
| DATE 09.09.23 | DATE 04.04.24 | DATE 09/09/25 | DATE 09/09/30 | | DATE 09/09/30 | | |

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS.~~ COAT ALL EXPOSED FASTENERS WITH
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02

MP

celo 62943

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